

Date: Tuesday, 10/30/2007 2:49:10 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SLIDING PLATE
Job Number	: 35443		
Estimate Number	: 11215		
P.O. Number	: <u>N/A</u>	Part Number	: D33333
This Issue	: 10/30/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3333 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 31520	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 11/15/2007 Qty: <u>10</u> Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est. A 05.01.13 New issue KJJLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B4000X00500	AISI 1010-1025 Steel Bar
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Comment: Qty.: 0.7984 f(s)/Unit Total : 4.7905 f(s)

AISI 1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel

(M1010-B4.000x00.500)

Identify for D3333-3

Batch: M104135

SA 07/11/24

(10)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 4.000" x 0.500" thick x 9.620" long

SA 07/11/24

(10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA483 and Dwg D3333

Identify as D3333-3

ML/J.F. 07/11/24

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML/J.F. 07/11/24

PTO

(10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EG 07.11.26

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 07/11/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.11.27	4.0	0.485 is 0.465 in center of part R.C. mat to Bored	LE 07.11.27	Acceptable.	LE 07.11.27	✓ 07.11.27	LE 07.11.27	C 07.11.27

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:49:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING PLATE

Job Number: 35443

Part Number: D33333

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr and Grind 45° chamfer on opposite side of pocket along edges as per Dwg D3333

WJ 07/11/27

(10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

WJ 07/14/27 (10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Ensure to mask threaded holes and sides

WJ 07/14/27 (10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

WJ 07/14/27 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST490

WJ 07/14/28 (10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

WJ 07/11/28 (10)

Job Completion



WJ 07/11/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35443
Description: Sliding Plate		Part Number:	D3333-3
Inspection Dwg: D3333 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	+/-0.010	3.897"	✓			
9.50	+/-0.030	9.500"	✓			
0.650	+/-0.010	.648"	✓			
2.310	+/-0.010	2.310"	✓			
1.125	+/-0.010	1.125"	✓			
1.950	+/-0.010	1.950"	✓			
1.200	+/-0.010	1.200"	✓			
1.300	+/-0.005	1.302"	✓			
R0.125	+/-0.010	R0.125"	✓			
0.500	+/-0.010	.500"	✓			
0.440	+/-0.010	.445"	✓			
1.675	+/-0.010	1.673"	✓			
0.035 x 45°	+/-0.010 x 0.5°	.030" x 45°	✓			
0.485	+0.000/-0.010	.480"	✓			
1.11	+/-0.030	1.115"	✓			
3/8 - 24 UNF	N/A	3/8 - 24 UNF	✓			
0.450	+/-0.010	.440"	✓			

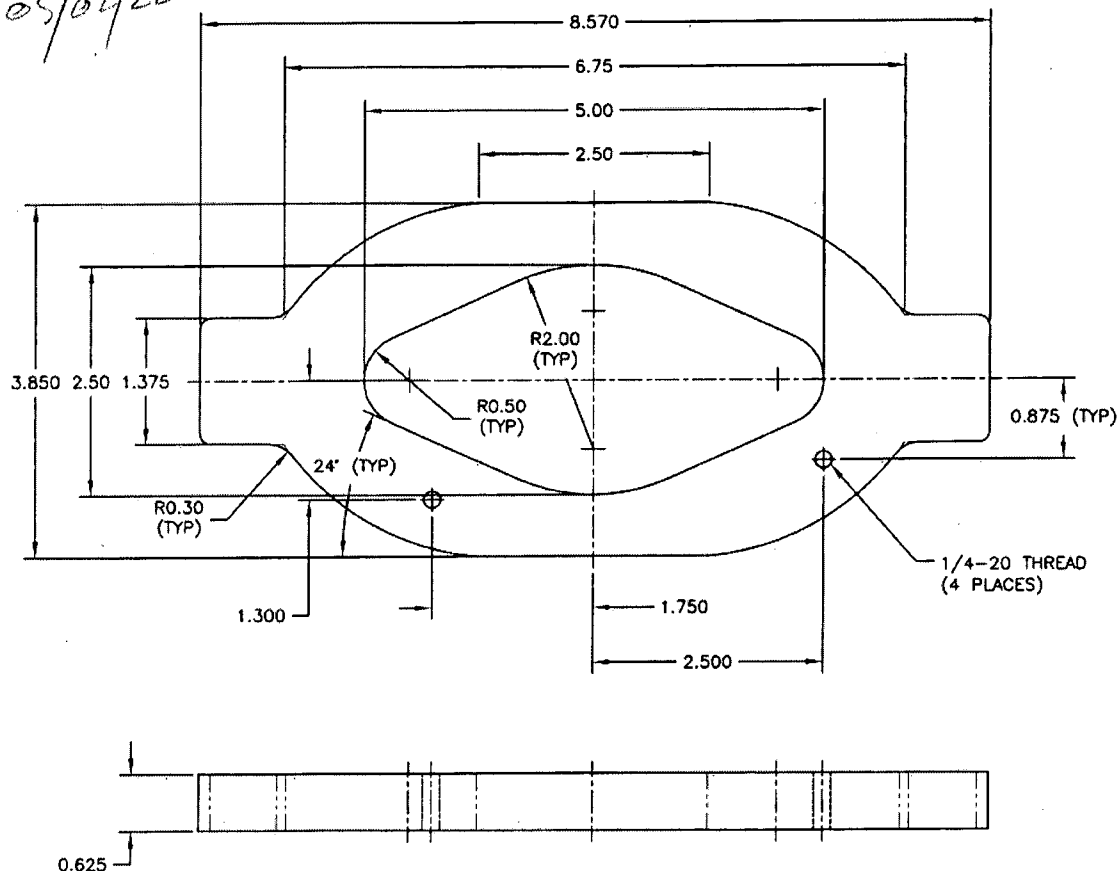
Measured by: J.F.	Audited by: [Signature] 07.11.24	Prototype Approval:	N/A
Date: 07/11/24	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM [Signature]	[Signature]



DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED JF	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B) MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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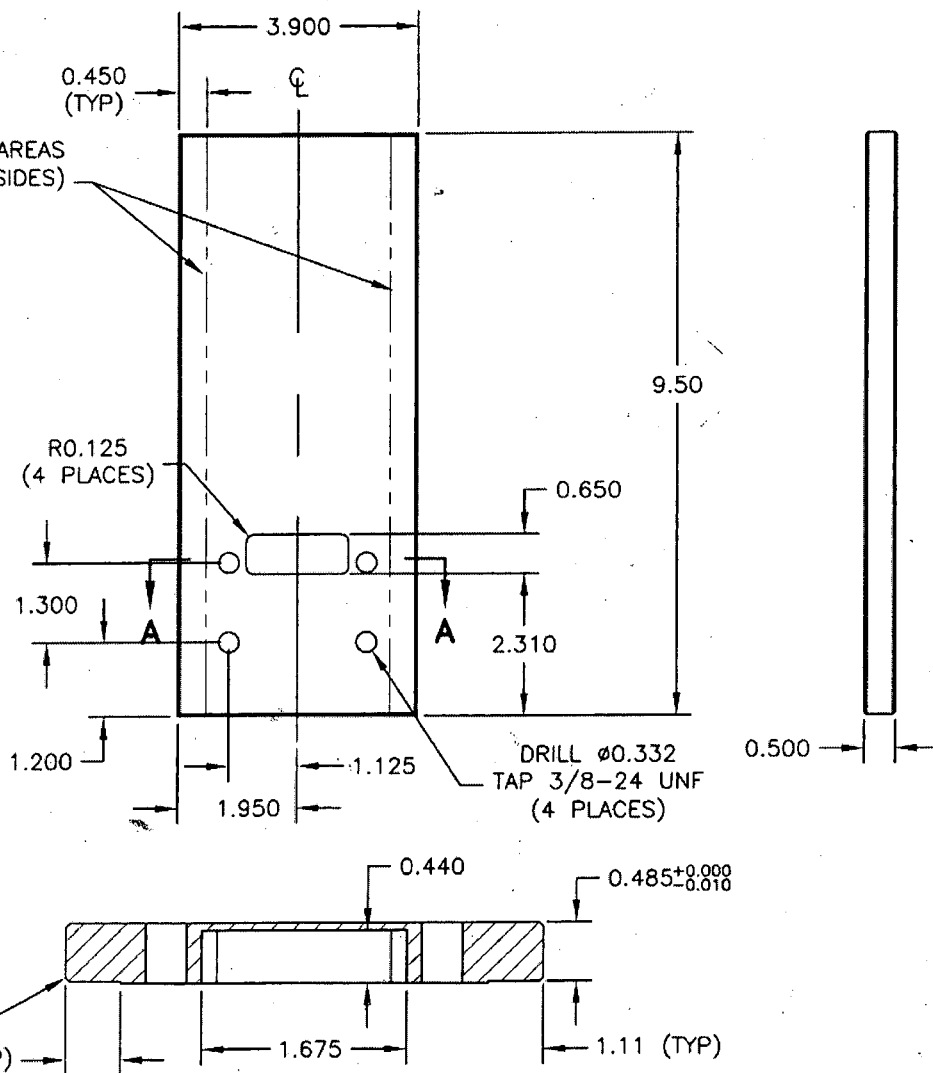
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DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED
05/02/22

DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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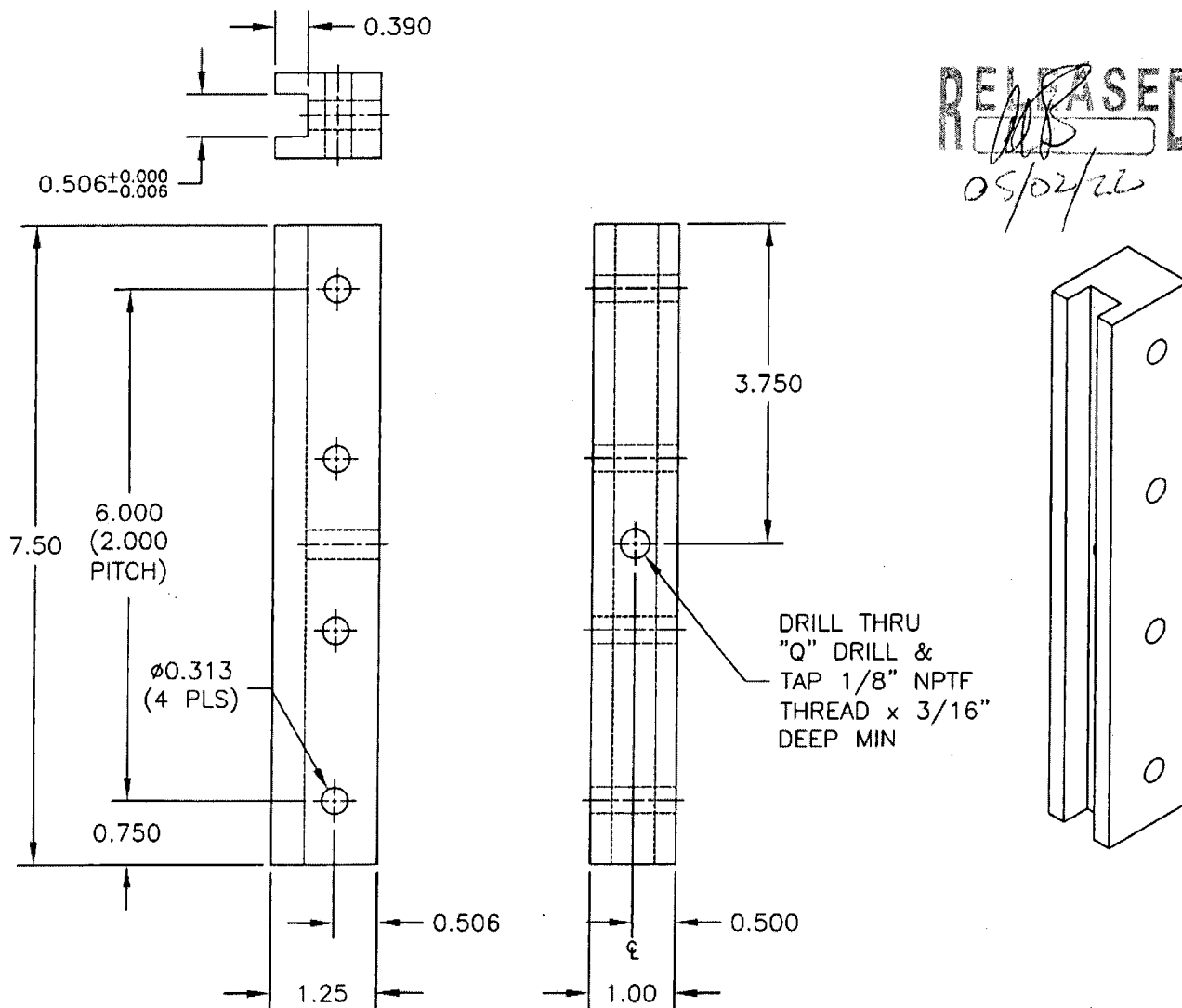
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18	TITLE PLATE		SCALE 1:2



D3333-5 RAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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